

# Work Order ID 70509

Friday, June 10, 2011 10:24:20 AM



Page 1

Item ID: D4403-8

Accept



Setup Start



Revision ID:

Item Name: Vertical Rib, RH

Stop



Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00

Customer:

Reference:

*7/11-06-10*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4403

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

*amk 11/06/10*

Jeaspa Bandsaw

CUT BLANK AT 7.250"

*2* *0*

110

0.00



HAAS 1

Memo

0.00

*amk 11/06/15*

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FB061 & DWG  
FOLIO REV: *AA*  
DWG REV: *A*

*2* *0*

DEBURR

**Work Order ID 70509**

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Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		<i>ml 11/06/15</i>		<i>2</i>	<i>0</i>		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>SL 11/06/15</i>					
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<i>2</i>	<i>6</i>	<i>11/06/15</i>	

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Item Name: Vertical Rib, RH

Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>139F</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

#2 BR 11-6-15

11/6/16 208

11/6/16

ME  
11-06-16

# Picklist Print

Page 1

Friday, June 10, 2011 10:24:17 AM

Work Order ID: 70509



Parent Item: D4403-8



Parent Item Name: Vertical Rib, RH

Start Date: 6/13/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

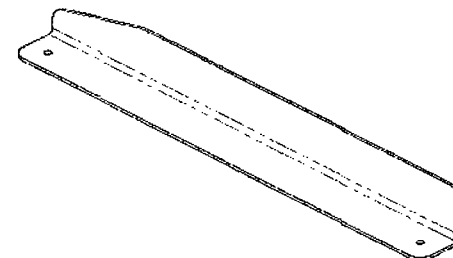
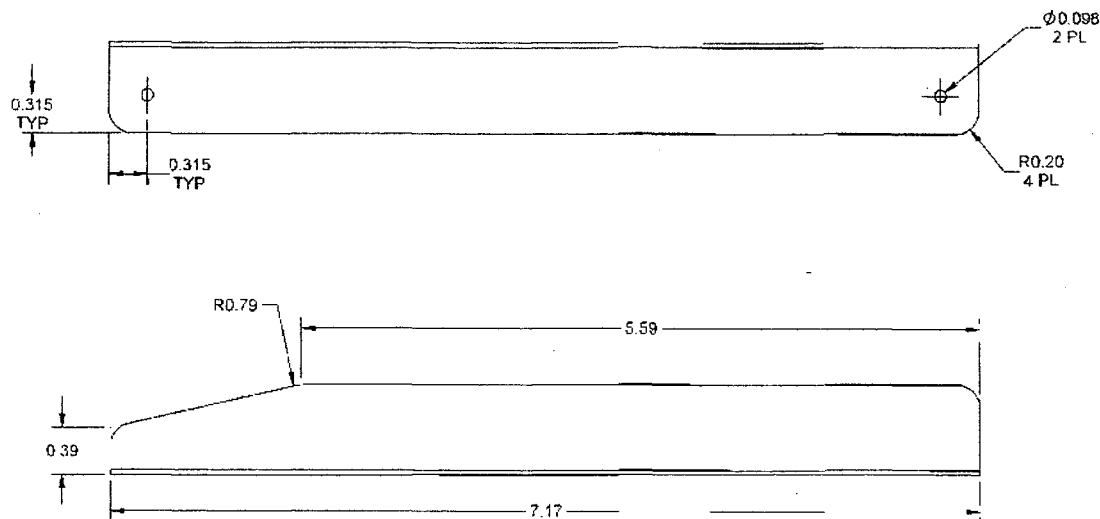
Comments: IPP REV: A NEW ISSUE 11/06/08 JFS VERIFY BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A0.750X0.750 X.040		Purchased	No			100	f	0.0000	0.6	1.263158			

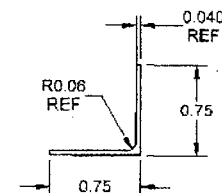


2024-T3 ANGLE .750' X .750 X .040" WALL

M117637 X 1.26" and 11/06/10



w/o 70509







# **D4403-8 VERTICAL RIB, RH**

## **NOTES:**

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE  
PER QQ-A-200/3  
OR AMS 4152, 4164 & 4165  
REF DART SPEC M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QS1005 4.1
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QS1044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) SIMILAR TO AGUSTA P/N 3G2591A07551

**RELEASED**  
2011-05-24  
AW

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. A
MFG. APPR		<b>D4403</b>	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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